

AMENDMENTS TO THE CLAIMS

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claims 1 - 10 (Cancelled)

11. **(Withdrawn)** An apparatus for producing a multilayered (n-layered) unstretched film according to a multi-manifold method that comprises separately heating and melting a plural number (n: n is a natural number, and the same shall apply hereinafter) of thermoplastic resins, then widening the heated and melted, plural thermoplastic resins through the respective manifolds and thereafter combining and extruding them to produce a multilayered (n-layered) unstretched film; the apparatus comprising a plural number (n) of extruders (A1 to An) for separately heating and melting the plural thermoplastic resins to constitute the respective layers of the multilayered (n-layered) unstretched film, at least one extruder (B) for heating and melting another thermoplastic resin than the plural thermoplastic resins, a plural number (n) of ducts (C1 to Cn) for resin melt supply each connected to the respective extruders (A1 to An), a plural number (n) of ducts (D1 to Dn) for resin melt supply each connected to the extruder (B), a plural number (n) of feed blocks where two holes are formed on both sides of the lower part of the ducts (C1 to Cn) for resin melt supply and are connected to the ducts (D1 to Dn) for resin melt supply, a plural number (n) of manifolds, one die lip connected to each manifold, and one T-die connected to each feed block.

12. **(Withdrawn)** The apparatus for producing a multilayered unstretched film as claimed in claim 11, wherein, in each of the plural feed blocks, the cross section of the lower part of each duct to which the plural thermoplastic resins are fed is rectangular, and the cross section of the holes formed on both sides of the lower part of the duct is rectangular.

13. (Cancelled)

14. **(Currently amended)** A method for producing a multilayered unstretched film comprising:

(a) heating and melting a first thermoplastic resin in a first extruder, heating and melting a second thermoplastic resin in a second extruder;

(b) heating and melting an edge-forming thermoplastic resin in another extruder;

(c) feeding the first heated and melted thermoplastic resin through a first melt supply duct, feeding the second heated and melted thermoplastic resin through a second melt supply duct;

(d) conveying the heated and melted edge-forming thermoplastic resin to a feed block through a third melt supply duct and a fourth melt supply duct;

(e) leading the edge-forming thermoplastic resin to both ~~sides-edges~~ of the first thermoplastic resin through a first hole, and to both ~~sides-edges~~ of the second thermoplastic resin through a second hole, wherein the first hole is ~~formed-located~~ on both ~~sides-edges~~ of the lower part of the first melt supply duct, and the second hole is ~~formed-located~~ on both ~~sides-edges~~ of the lower part of the second melt supply duct, and which holes are connected to the end of the third melt supply duct and the fourth melt supply duct;

(f) widening the so-formed side-by-side combination of the first thermoplastic resin and the edge-forming thermoplastic resin in a first manifold and widening the so-formed side-by-side combination of the second thermoplastic resin and the edge-forming thermoplastic resin for edge part in a second manifold;

(g) combining widened thermoplastic resins at a location immediately above a T-die and laminating the thermoplastic resins; and

(h) ejecting the laminated thermoplastic resins through a die lip of the T-die onto a casting roll disposed below the T-die,

wherein the difference in the melt viscosity between the thermoplastic resins and the edge-forming thermoplastic resin is at most 3000 poise at a 100 sec⁻¹ shear rate.

15. **(Currently amended)** A method for producing a multilayered unstretched film comprising:

(a) heating and melting a first thermoplastic resin in a first extruder, heating and melting a second thermoplastic resin in a second extruder;

(b) heating and melting an edge-forming thermoplastic resin in an other extruder;

(c) feeding the first heated and melted thermoplastic resin through a first melt supply duct, feeding the second heated and melted thermoplastic resin through a second melt supply duct;

(d) conveying the heated and melted edge-forming thermoplastic resin to a feed block through a third melt supply duct and a fourth melt supply duct;

(e) leading the edge-forming thermoplastic resin to both ~~sides-edges~~ of the first thermoplastic resin through a first hole, and to both ~~sides-edges~~ of the second thermoplastic resin through a second hole, wherein the first hole is ~~formed-located~~ on both ~~sides-edges~~ of the lower part of the first melt supply duct, and the second hole is ~~formed-located~~ on both ~~sides-edges~~ of the lower part of the second melt supply duct, and which holes are connected to the end of the third melt supply duct and the fourth melt supply duct;

(f) widening the so-formed side-by-side combination of the first thermoplastic resin and the edge-forming thermoplastic resin in a first manifold and widening the so-formed side-by-side combination of the second thermoplastic resin and the edge-forming thermoplastic resin for edge part in a second manifold;

(g) combining widened thermoplastic resins at a location immediately above a T-die and laminating the thermoplastic resins;

(h) ejecting the laminated thermoplastic resins through a die lip of the T-die onto a metal sheet disposed below the T-die, wherein the width of the die lip is larger than width of the metal sheet; and

(i) cutting off thermoplastic resins protruding from both edges of the metal sheet, and

wherein the difference in the melt viscosity between the thermoplastic resins and the edge-forming thermoplastic resin is at most 3000 poise at a 100 sec^{-1} shear rate.

16. **(Previously Presented)** The method for producing a multilayered unstretched film according to claim 14 further comprising:

(i) heating and melting at least one further thermoplastic resin in at least one further extruder;

(j) feeding at least one further heated and melted thermoplastic resin through at least one further melt supply duct;

(k) conveying the heated and melted edge-forming thermoplastic resin to the feed block through melt supply ducts respectively;

(l) leading the edge-forming thermoplastic resin to both sides of at least one further thermoplastic resin through at least one further hole, wherein the at least one further hole is formed on both sides of the lower part of at least one further melt supply duct, and which holes are respectively connected to each hole formed on both sides of each melt supply duct; and

(m) widening the so-formed side-by-side combination of at least one further thermoplastic resin and the edge-forming thermoplastic resin in at least one further manifold.

17. **(Previously Presented)** The process for producing a multilayered-resin-coated metal sheet according to claim 15 further comprising:

(j) heating and melting at least one further thermoplastic resin in at least one further extruder;

(k) feeding at least one further heated and melted thermoplastic resin through at least one further melt supply duct;

(l) conveying the heated and melted edge-forming thermoplastic resin to the feed block through melt supply ducts respectively;

(m) leading the edge-forming thermoplastic resin to both sides of the at least one further thermoplastic resin through at least one further hole, wherein at least one further hole is formed on both sides of the lower part of at least one further melt supply duct, and which holes are respectively connected to each hole formed on both sides of each melt supply duct; and

(n) widening the so-formed side-by-side combination at least one further thermoplastic resin and the edge-forming thermoplastic resin in at least one further manifold.

18. **(Currently Amended)** The process for producing a multilayered unstretched film according to claim 14, wherein the edge-forming thermoplastic resin has substantially no lapping part in a cross sectional view of the laminated thermoplastic resins, ~~the length of the edge-forming thermoplastic resin is uniform.~~

19. **(Currently Amended)** The process for producing a multilayered unstretched film according to claim 16, wherein the edge-forming thermoplastic resin has substantially no lapping part in a cross sectional view of the laminated thermoplastic resins, ~~the length of the edge-forming thermoplastic resin is uniform.~~

20. **(Previously Presented)** The process for producing a multilayered unstretched film according to claim 14, wherein

- (a) a cross section of the lower part of each melt supply duct is rectangular; and
- (b) a cross section of holes is rectangular.

21. **(Previously Presented)** The process for producing a multilayered unstretched film according to claim 16, wherein

(a) a cross section of the lower part of each melt supply duct is rectangular;
and

(b) a cross section of holes is rectangular.

22. **(Currently amended)** The process for producing a multilayered unstretched film according to claim 14, ~~wherein the difference in the melt viscosity between the thermoplastic resins and the edge-forming thermoplastic resin is at most 3000 poise at a 20 to 500 sec⁻¹ shear rate and~~ wherein the melt viscosity of the thermoplastic resins is lower than the melt viscosity of the edge-forming thermoplastic resin.

23. **(Currently amended)** The process for producing a multilayered unstretched film according to claim 16, ~~wherein the difference in the melt viscosity between the thermoplastic resins and the edge-forming thermoplastic resin is at most 3000 poise at a 20 to 500 sec⁻¹ shear rate and~~ wherein the melt viscosity of the thermoplastic resins is lower than the melt viscosity of the edge-forming thermoplastic resin.

24. **(Previously Presented)** The process for producing a multilayered unstretched film according to claim 14, wherein the edge-forming thermoplastic resin is a colored thermoplastic resin.

25. **(Previously Presented)** The process for producing a multilayered unstretched film according to claim 16, wherein the edge-forming thermoplastic resin is a colored thermoplastic resin.

26. **(Currently amended)** The process for producing a multilayered unstretched film according to claim 15, ~~wherein the difference in the melt viscosity between the thermoplastic resins and the edge-forming thermoplastic resin is at 3000 poise at a 20 to 500 sec⁻¹ shear rate and~~ wherein the melt viscosity of each of the thermoplastic resins is lower than the melt viscosity of the edge-forming thermoplastic resin.

27. **(Currently amended)** The process for producing a multilayered unstretched film according to claim 17, ~~wherein the difference in the melt viscosity between the thermoplastic resins and the edge-forming thermoplastic resin is at 3000 poise at a 20 to 500 sec⁻¹ shear rate and~~ wherein the melt viscosity of each of the thermoplastic resins is lower than the melt viscosity of the edge-forming thermoplastic resin.

28. **(Previously Presented)** The process for producing a multilayered resin-coated metal sheet according to claim 15, wherein the edge-forming thermoplastic resin is a colored thermoplastic resin.

29. **(Previously Presented)** The process for producing a multilayered resin-coated metal sheet according to claim 17, wherein the edge-forming thermoplastic resin is a colored thermoplastic resin.